

Date: Thursday, 11/06/2009 12:50:43 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : TUBE ASSEMBLY 23"
<b>Job Number</b> : 48509	
<b>Estimate Number</b> : 11192	
<b>P.O. Number</b> :	<b>Part Number</b> : D3298005
<b>This Issue</b> : 11/06/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3298 REV A2
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A2
<b>Previous Run</b> : 47505	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 19/06/2009 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JWD 09.06.11</u>	
<b>Comment</b> : Est A04.09.02 New issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6T0375W035	6061-T6 RD Tube .375 x.035W
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10X

**Comment:** Qty.: 2.0124 f(s)/Unit Total : 20.1243 f(s)

Cut tube to length as per Dwg D3298

Material: 6061-T6 (WW-T-700/6) tubing Ø0.375" x 0.035" wall (M6061T6T0.375W.035)

Identify as D3298-005

Batch: \_\_\_\_\_

M 104913

M. 09/06/18

2.0	MS208196D	Sleeve
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Sleeve

Pick:

Qty Part Number Description Batch

2 MS20819-6D Sleeve

M 110916

M. 09/06/18

3.0	AN8186D	Nut
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Coupling Nut

Pick:

Qty Part Number Description Batch

2 AN818-6D Nut

M 108940

M. 09/06/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 11/06/2009 12:50:44 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY 23"

Job Number: 48509

Part Number: D3298005

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



10x

Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend tube as per template D3298-005T1 & Dwg D3298

Flare end as per Dwg D3298.

Ensure that sleeves and coupling are installed first

M-L 09/06/18

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sort 06/18 (K)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



10x

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 195

2/6/19

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/22 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.06.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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DATE 04.07.06		TITLE TUBE ASSEMBLIES	SCALE NTS
A	04.07.06	NEW ISSUE	
A1	<i>[Signature]</i> 04.11.30	CORRECT VIEW D3298-003; 16.50 WAS 15.75	
A2	<i>[Signature]</i> 05.05.06	FOR D3298-001/-003 16.00 WAS 16.50	

**RELEASED**  
04.07.09 *[Signature]*

P/N	TEMPLATE	CUT LENGTH OF TUBE	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL
D3298-001	D3298-001T1	25.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-003	D3298-003T1	27.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-005	D3298-005T1	23.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-007	D3298-007T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-009	D3298-009T1	6.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-011	D3298-011T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-013	D3298-013T1	10.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-015	D3298-015T1	14.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)

**Notes:**

- (1) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (2) TUBES TO BE FLARED 37° TO MATE WITH FITTINGS MADE TO MS33514.
- (3) ENSURE SEAMLESS TUBING IS USED.
- (4) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- (6) ALL DIMENSIONS ARE IN INCHES
- (7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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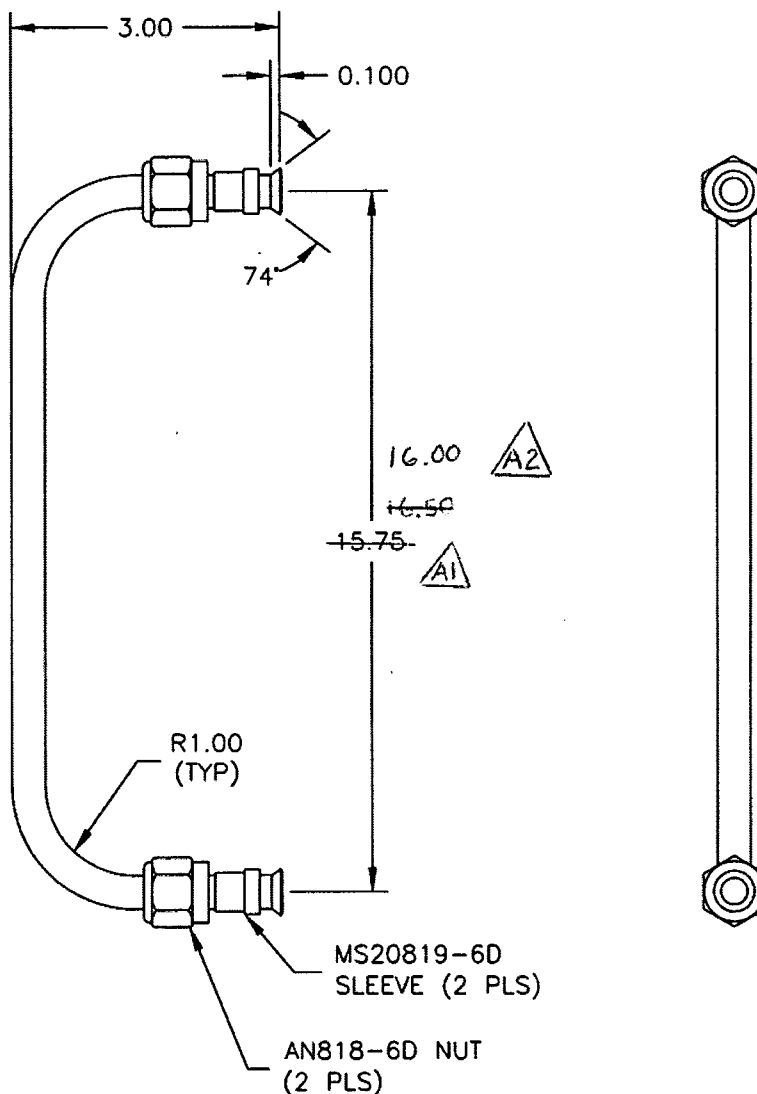
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D3298-001

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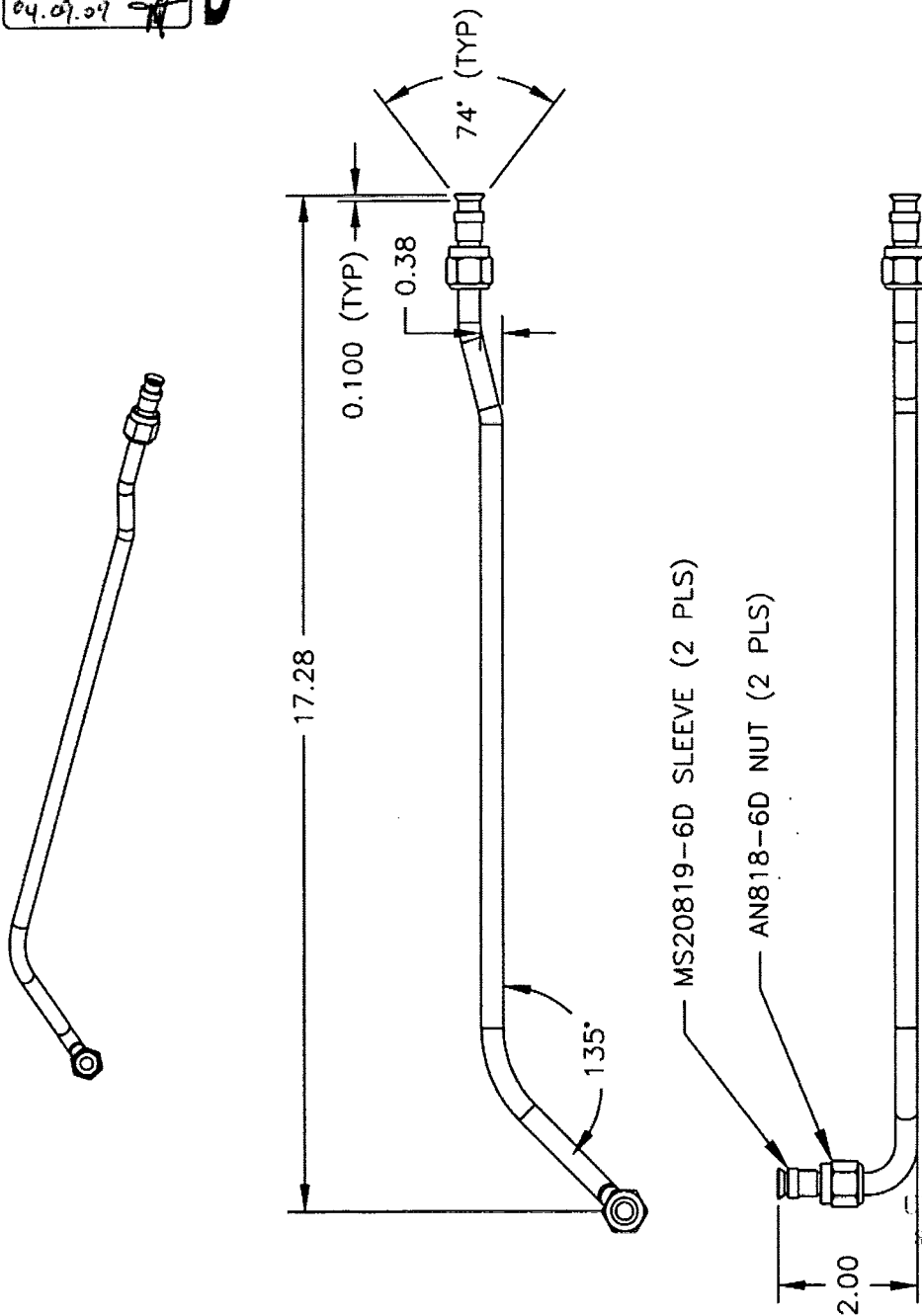
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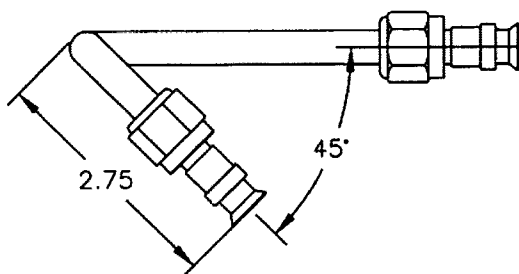
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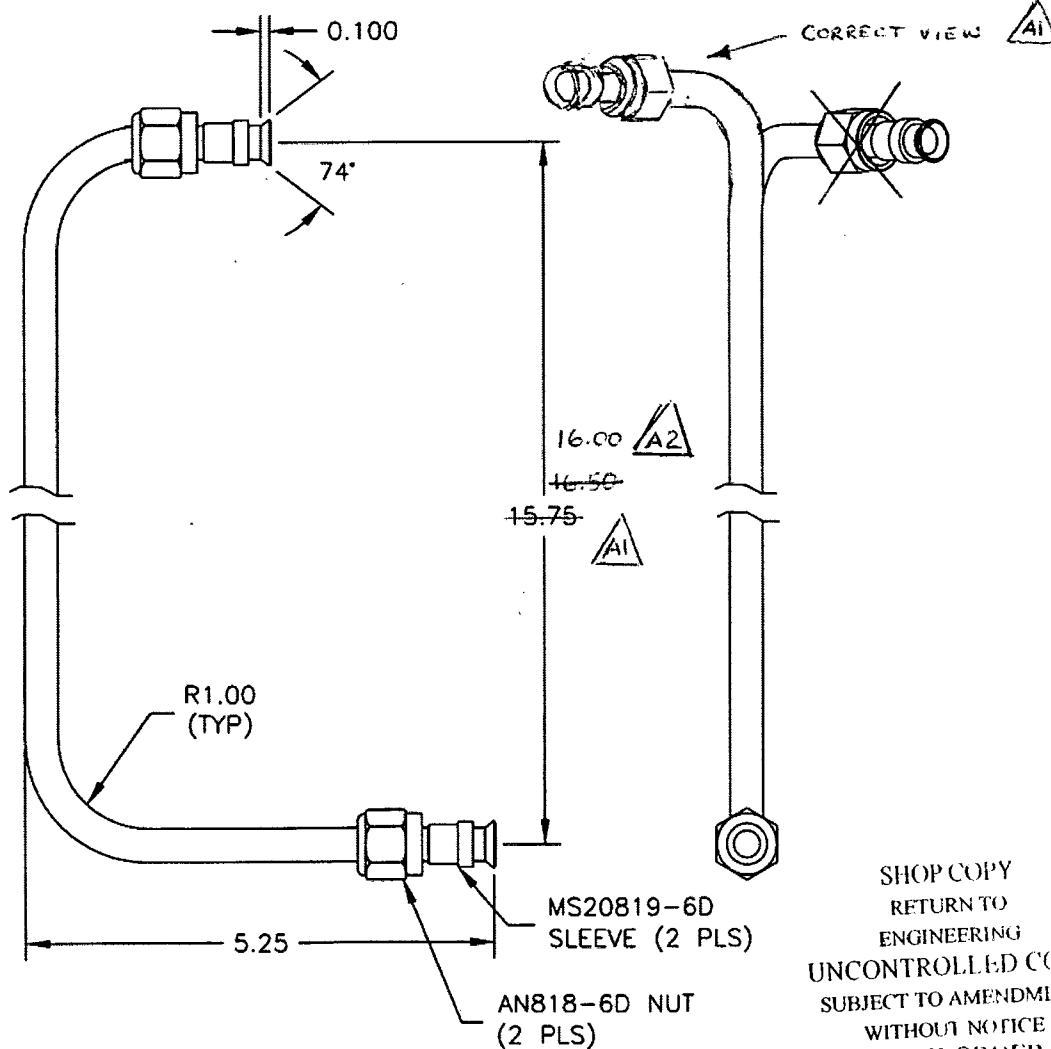


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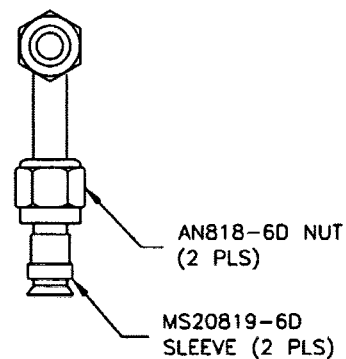
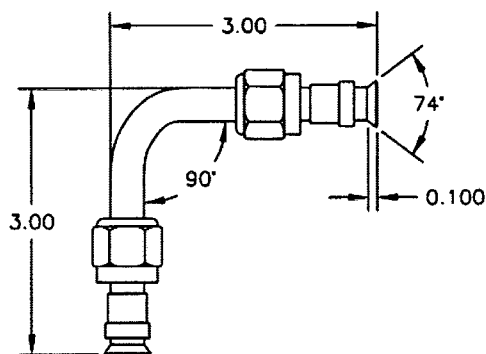
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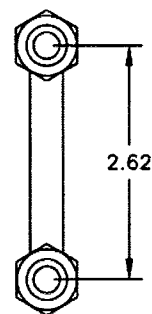
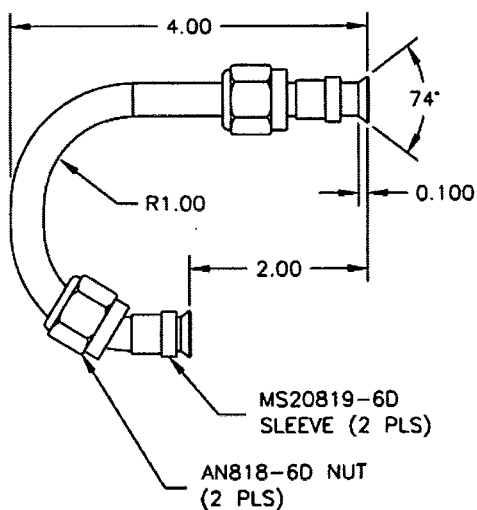


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**D3298-013**

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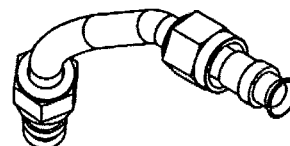
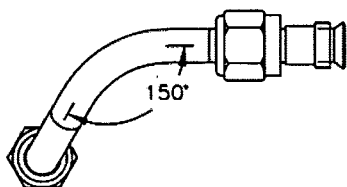
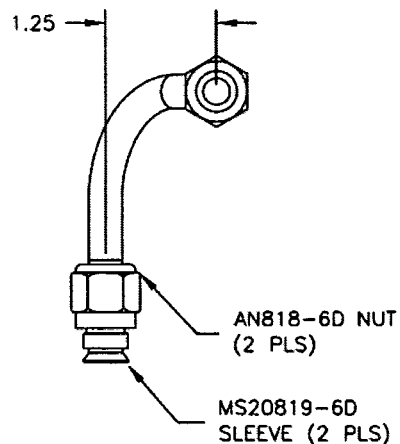
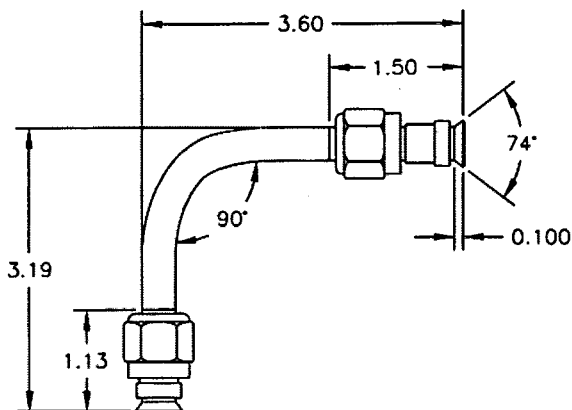
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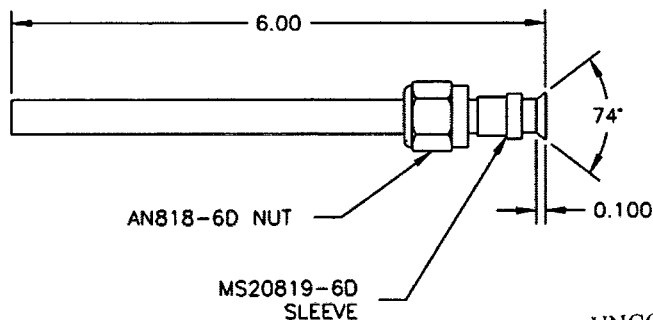


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D3298-009

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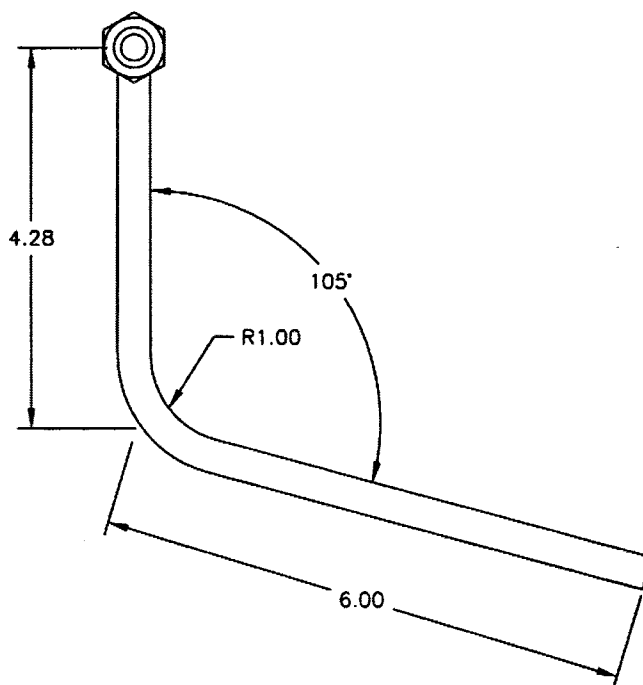
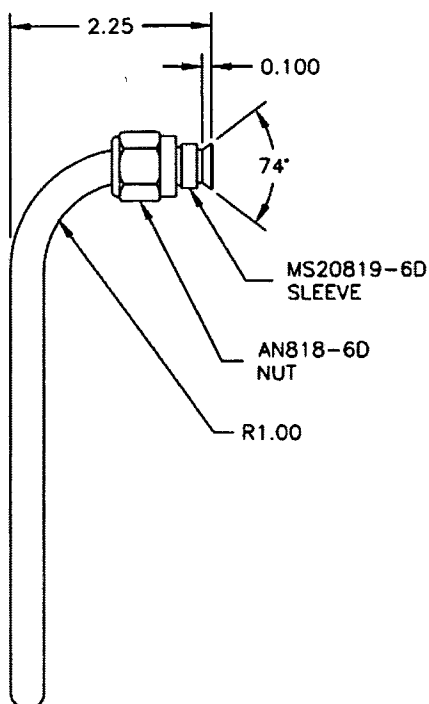
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